

Date: Wednesday, 2/6/2008 10:24:15 AM  
User: Kim Johnston

Dart Aerospace Ltd.

# SPLIT

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : WEARPAD

Job Number : 37238 - 3

Estimate Number : 12784

P.O. Number :

This Issue : 2/6/2008

S.O. No. :

Prsht Rev. : NC

First Issue : 1/1

Type : SMALL / MED FAB

Previous Run : 36637

Part Number : D35649

Drawing Number : D3564 REV D

Project Number : N/A

Drawing Revision : D

Material :

Due Date : 2/18/2008

Qty: 12 Um: Each

Written By :

Checked & Approved By :

Comment :

Est Rev: A New Issue 07-03-08 ec

Est Rev: B As per Rev C 07-07-09 JLM

Est Rev: C As per Rev D 07-09-09 JLM Verified By: EC

Additional Product

Job Number:

Seq. #: Machine Or Operation:

Description :

1.0

M304S16GA

304/316 .063 Sheet

Comment: Qty.: 1.1550 sf(s)/Unit Total: 13.8600 sf(s)

M304S16GA Stainless steel sheet 0.063" thick

Batch: 106860 IB 8-2-11

2.0

WATER JET

FLOW WATER JET

Comment: FLOW WATER JET

1-Cut as per Dwg D3564 \*\*\*\*\* (D3564-1F) \*\*\*\*\*

Dwg Rev: D

Prog Rev: D

2-Deburr if necessary

IB 8-2-11

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Deburr if necessary

Form on Brake as per Dwg D3564 using Jigs DT 8155 and DT 8175

Form Joggle as per Dwg D3564 on brake using Jig DT 8157





## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 37238

Part Number: D35649

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

*June 20 12*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

A/R 2059B Hardcoat

Batch

*M106834*

Weld hardcoat as per Dwg D3564

*dy 08/03/10 7x*

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 08-03-10 7*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*dy 08/03/10 7x*

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*M106442**FL 08/03/11 7*

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-03-11 7x*

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP-18**dy**08-03-11 7x*

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*dy 08/03/10*

Job Completion

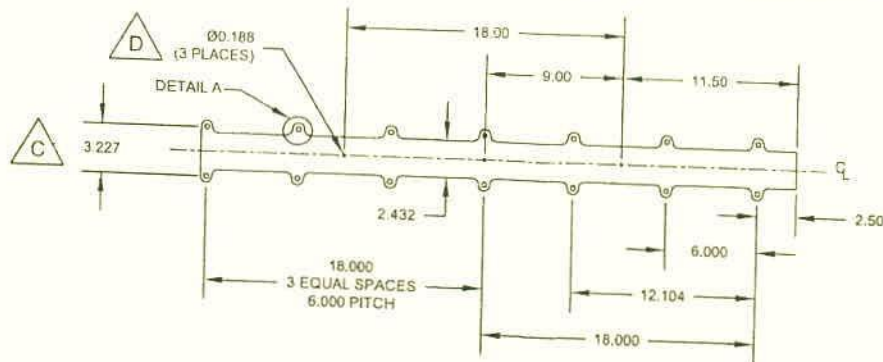
*2008/3/11 7*







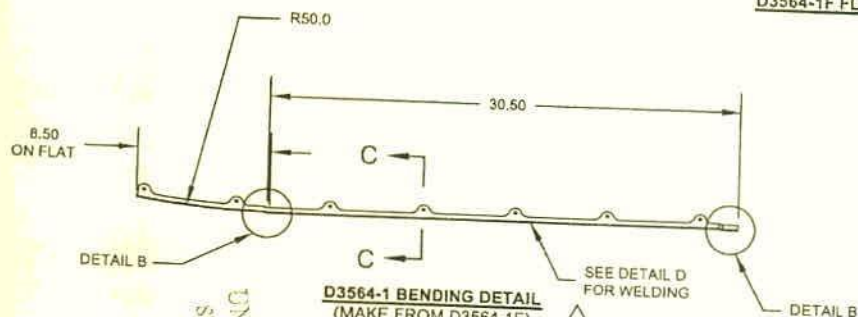




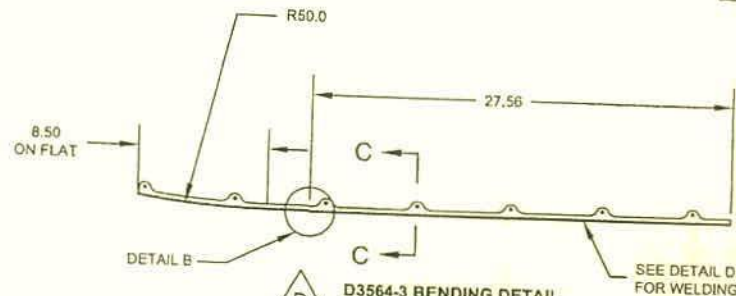
**D3564-1F FLAT PATTERN**

RELEASED

07.09.04



**D3564-1 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-3 BENDING DETAIL**  
(MAKE FROM D3564-1F)

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**D3564-1/-3/-5/-7/-9/-11/-13/-15 WEARPLATE NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE TABLE IN ZONE A3
- 8) WELD PER DART QSI 004
- 9) SEE PG 3 FOR SECTIONS AND DETAILS
- 10) PARTS ARE SYMMETRIC ABOUT C

**WEIGHTS:**

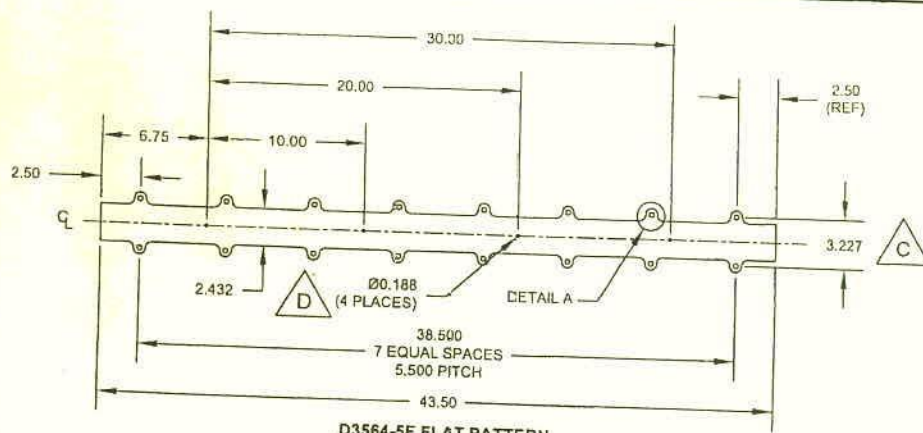
D3564-1	1.85 lbs
D3564-3	1.85 lbs
D3564-5	1.93 lbs
D3564-7	1.26 lbs
D3564-9	1.85 lbs
D3564-11	1.85 lbs
D3564-13	0.38 lbs
D3564-15	0.80 lbs

D	UPDATE DRAWING TEMPLATE; CHANGE ALL (TYP X PLS) TO (X PLACES); PG1 A8: UPDATE NOTES; PG1 A8, PG3 B5,C5: ADD D3564-15; PG1 B6,B3: D3564-1/-3 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ONE FIGURE; PG2 A7,A3: D3564-9/-11 WAS ON PG1; PG3 B8,C8: D3564-13 WAS ON PG2; PG3 D2: WELDING DETAIL WAS ON PG1 PG3 A5,7,B2: RELOCATE DETAILS AND SECTION; PG3 A5,7,B2: INCREASE DETAIL AND SECTION SIZE	CB	07.08.21
C	MOVE TAB OUTBOARD, DETAIL A	PH	07.04.17
B	ADD AMS 5513 AND AMS 5524	PH	07.03.20
A	NEW ISSUE	PH	06.12.18
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	CB		
CHECKED	PH		
MFG. APPR.	21		
APPROVED	21		
DE APPR.	21		
DATE	07.08.21		
<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3564 TITLE WEARSHOE SCALE 1:8 REV. D SHEET 1 OF 3 COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL. THIS IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

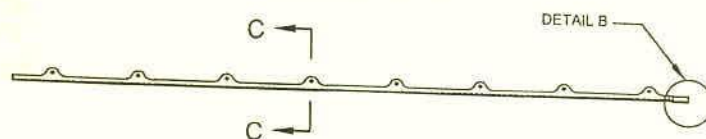




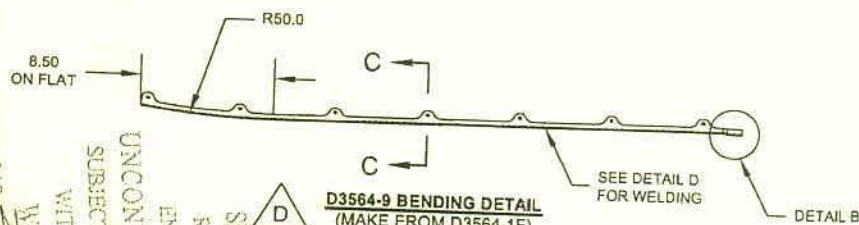




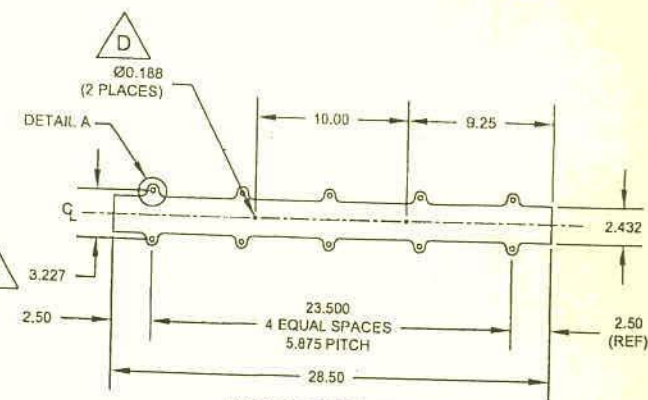
**D3564-5F FLAT PATTERN**



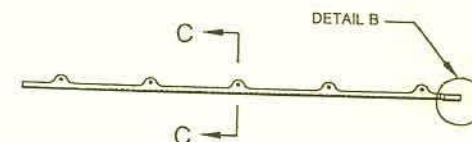
**D3564-5 BENDING DETAIL**  
(MAKE D3564-5 FROM D3564-5F)



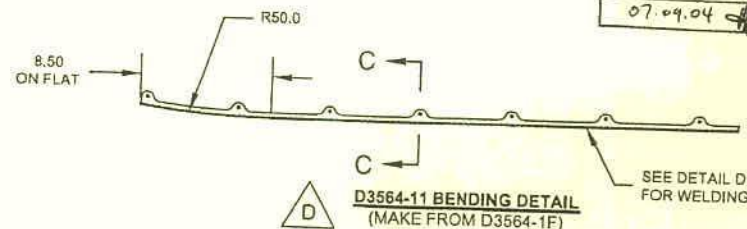
**D3564-9 BENDING DETAIL**  
(MAKE FROM D3564-1F)



**D3564-7F FLAT PATTERN**



**D3564-7 BENDING DETAIL**  
(MAKE D3564-7 FROM D3564-7F)



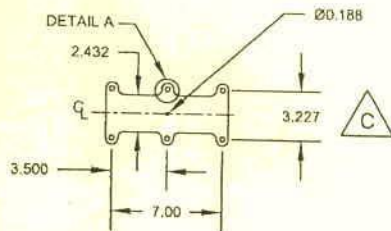
**D3564-11 BENDING DETAIL**  
(MAKE FROM D3564-1F)

RELEASED  
07.09.04

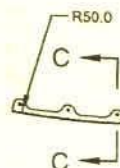
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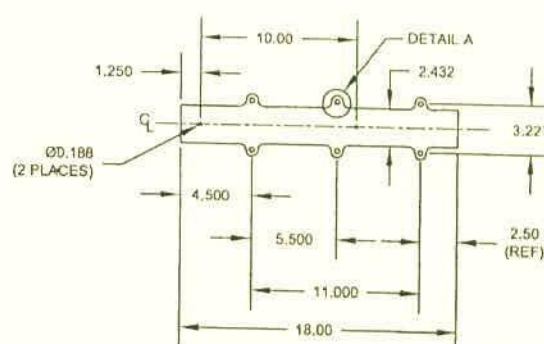




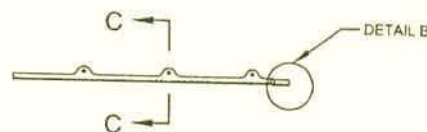
**D3564-13F FLAT PATTERN**



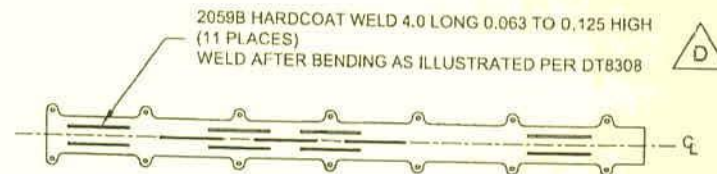
**D3564-13 BENDING DETAIL**  
(MAKE D3564-13 FROM D3564-13F)



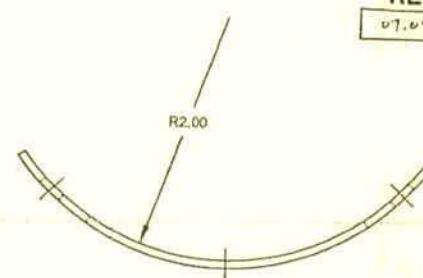
**D3564-15F FLAT PATTERN**



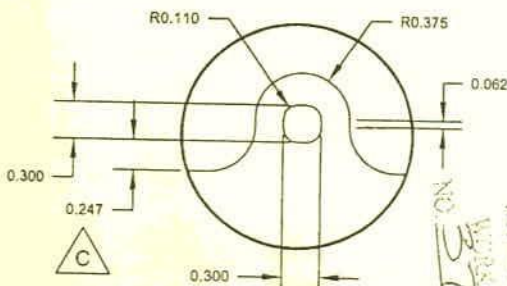
**D3564-15 BENDING DETAIL**  
(MAKE D3564-15 FROM D3564-15F)



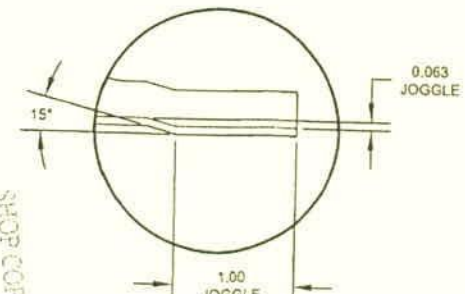
**DETAIL D**  
(D3564-1/3/9/11 WELDING DETAIL)



**SECTION C-C**  
SCALE 1:1



**DETAIL A**  
SCALE 1:1



**DETAIL B**  
SCALE 1:1

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